

Work Order ID 59718

Thursday, June 10, 2010 8:08:33 AM



Page 1

Item ID: D2017-115

Accept



Setup Start



Revision ID:

Item Name: Step Struts

Stop



Start Date: 6/10/2010 Start Qty: 7.00



Cust Item ID:

Required Date: 6/11/2010 Req'd Qty: 7.00



Customer:

Reference:

Approvals:

Process Plan:

MF

Date: 10-6-10 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2017

Rev F

100

0.00



Brake NC

Memo

0.00

Punch tube type 304-2B
Drill hole to .312" as per Dwg. *MF*
and spec control D2638
Deburr

SD 10/06/10

=> M.K 10/06/17

(7)

(7X)

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

SD 10/06/17

(+7)

Quality Control

120

White Gloss(Ref:4.3.5.2) per QSI005.4.3-Steel

0.00



Powdercoat

Memo

0.00

Powder Coating

M.K 10/06/17

START 3:35

DU. 400°

FINISH 4:05

7 BR 10-6-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

ml 10 06 10 ⑦

140

Identify as per dwg & Stock Location: 252

0.00



Packaging

Memo

0.00

Packaging

10-6-18 ⑦

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/21

mf
10-6-21

Dart Aerospace Ltd

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Picklist Print

Thursday, June 10, 2010 8:08:33 AM

Page 1

Work Order ID: 59718

Parent Item: D2017-115

Parent Item Name: Step Struts

Comments: IPP ☐ E ☐ 02.06.19 ☐ Added finishing level (Ref. ECN 435) KJ/RF ☐

Start Date: 6/10/2010

Required Date: 6/11/2010

Start Qty: 7.00

Required Qty: 7.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.750W.049		Purchased	No			100	f	190.7568	1.058	7.795789			



304 RD Tube .750 x .049W



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT	162.89334	
108498	0	
114482	6.6065	
114852	156.28684	
MAT017	27.8635	
109314	9.33	
110113	5.29	
112800	13.2435	

9 SA 10/06/10

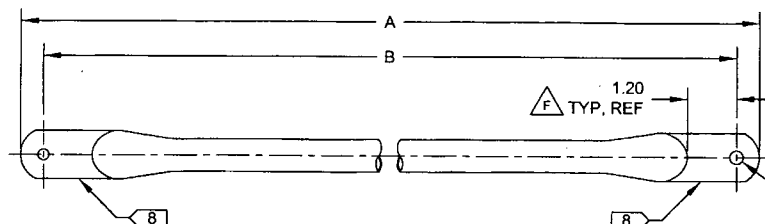
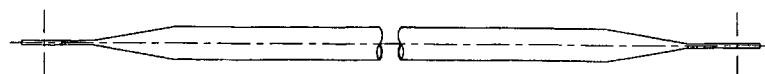
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NOTE: Date & initial all entries



Ø0.312
WIDEN HOLE
AFTER PUNCHING
1 END ONLY

8
EXCEPT
AS SHOWN

D2017-XXX STEP STRUT

PART NUMBER	A	B
D2017-101	17.73	16.93
D2017-103	18.74	17.94
D2017-113	20.50	19.70

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE, Ø0.750 x 0.049 WALL
REF. DART SPEC M304TR0.750W.049
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2017-XXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: N/A
- 8) PUNCH ENDS PER SPEC CONTROL DRAWING D2638.

RELEASED
29/04/16

F	DRAWING TRANSFERRED TO "B" FORMAT AND TO CURRENT STANDARDS. REDRAWN FOR CLARITY 1.20 REF DIM ADDED. SEE PAR 09-002 FOR DETAILS.	AJS	09.03.06
E	ENDS PUNCHED PER SPEC CTRL; -119 CHANGE (TSR A897) ADD FINISH (INCOPORATE E1)	CP	02.03.22
D	ADDED PARTS	BW	95.03.28
C	ADDED PARTS	BW	95.01.26
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2017	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		STEP STRUTS	NTS
DATE	09.03.06	<small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRELIMINARY AND NOT TO BE USED FOR ANY PURPOSES WITHOUT THE EXPRESS WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>	

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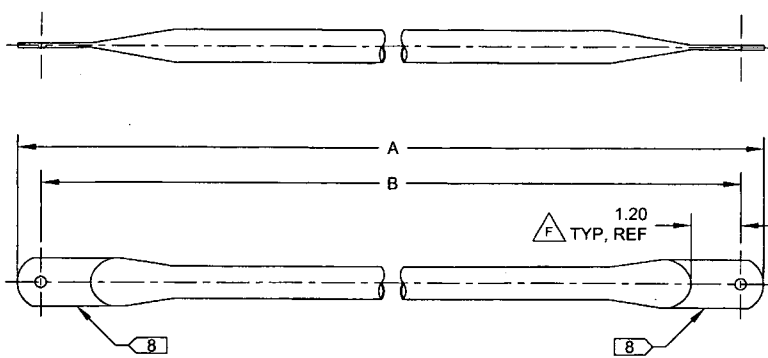
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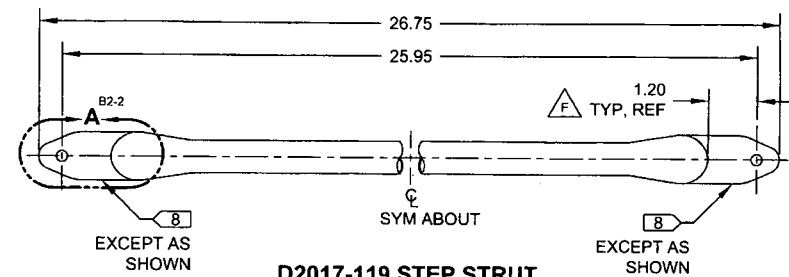
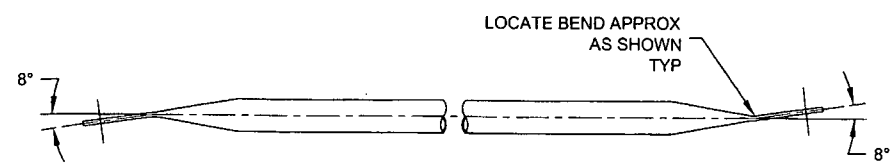
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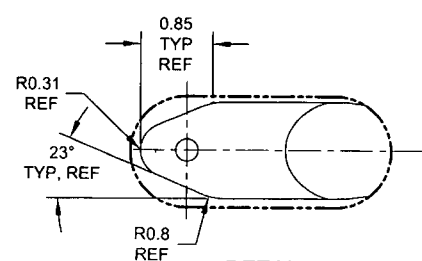


D2017-XXX STEP STRUT

PART NUMBER	A	B
D2017-105	14.95	14.15
D2017-107	15.61	14.81
D2017-109	13.93	13.13
D2017-111	15.30	14.50
D2017-115	12.42	11.62
D2017-117	13.86	13.06
D2017-121	12.30	11.50
D2017-123	12.92	12.12
D2017-125	19.55	18.75
D2017-127	20.30	19.50
D2017-129	31.43	30.63
D2017-131	19.68	18.88
D2017-201	21.31	20.51
D2017-203	16.39	15.59
D2017-205	16.53	15.73
D2017-207	13.85	13.05
D2017-209	15.64	15.33
D2017-211	15.67	14.87
D2017-213	15.82	15.02
D2017-215	16.47	15.67
D2017-217	16.70	15.90
D2017-219	13.65	12.85
D2017-221	13.58	12.78
D2017-223	12.95	12.15
D2017-225	13.99	13.19
D2017-227	30.67	29.87
D2017-133	30.66	29.86



D2017-119 STEP STRUT
(SHOWN PRIOR TO BENDING)



DETAIL A D4-2
TRIM AFTER PUNCHING PER DT8360
SCALE 2X

RELEASED
09/04/16

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	A/S		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2017	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		STEP STRUTS	NTS
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